

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016278**Date Inspected:** 04-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY # 08, OBG BIKE PATH (NWIT # 06331)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A1-058-009 (GREEN TAG NO. 13427)

BAY # 06, OBG DECK PLATE (NWIT # 06331)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

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DP3109-001-013, 014, 018, 019, 016, 017, 021, 022 (GREEN TAG NO. 13417)
DP3154-001-013, 014, 018, 019, 016, 017, 021, 022 (GREEN TAG NO. 13418)
DP3155-001-027, 028, 029, 035, 017, 022, 030, 031, 036, 037, 039, 040 (GREEN TAG NO. 13419)
DP3153-001-032, 031, 029, 030, 039~042 (GREEN TAG NO. 13422)

BAY # 08, OBG BIKE PATH (NWIT # 06332)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A6-058-068, 069, 084, 085, 094, 095, 112, 113
BK004A4-058-017, 018, 028, 043
BK004A7-058-087, 088, 093, 094, 171, 089, 090, 095, 096, 172
BK004A7-058-099, 100, 105, 106, 188, 101, 102, 107, 108, 193
BK004A-058-054, 069
BK004A7-058-111, 112, 117, 118, 210, 113, 114, 119, 120, 212
BK004A3-058-048, 054, 013, 028
BK004A7-058-023, 024, 148, 149, 153, 021, 022, 146, 147, 151
BK004A6-058-074, 075
BK004A7-058-003, 004, 009, 010, 125, 005, 006, 011, 012, 127

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay # 08, Bike Path

During random in process inspection this QA inspector observed that ZPMC NDT personnel was performing Magnetic Particle Testing (MT) on the fillet welds of OBG deck plate. The members are identified as OBG components and the weld designations reviewed are as follows.

DP3095-001-011, 012, 019, 020, 063, 064, 065, 066, 067, 068

BAY 07, Side Panel

SMAW tack welding of weld joint 63 located on SP3141B-001.
Welder is identified as 250833. ZPMC QC is identified as Mr. Wang Liang.
The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer